



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-698-015
Job Sheet 179206



Part No: D412-698-015

Job Qty: 1 ea

Part Name: Door Support - V Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:C Removed Manufacturing 06-01-25 JLM IPP Rev:D change to rev D ECN 1104
08-01-28 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Stores/Pkg-2		JUN 15 2018
110	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging1-4		JUN 15 2018
120	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC4		JRB
125	DC	1 pcs	6/22/18	6/22/18	0.00	0.00	DC		JRB
130	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-2		DAS 28
140	QC21-FG	1 Ea	6/22/18	6/22/18	0.00	0.00	QC21		21 18 26 18

Part Op 125 - Photocopy bluefile and create labels per PPP D412-698-015 CHG001
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3200-1	Door Post Block	2 Ea (2 ea)	90-Start up Operation	5036514
D3200-3	Door Wedge	2 Ea (2 ea)	90-Start up Operation	5035576
D3201-1	Doubler	2 Ea (2 ea)	90-Start up Operation	5038343
D3201-3	Angle	1 Ea (1 ea)	90-Start up Operation	5032990
D3201-4	Angle	1 Ea (1 ea)	90-Start up Operation	5032996
MS21042L3	Nut	12 Ea (12 ea)	90-Start up Operation	5038167
MS24693-S277	Screw	12 Ea (12 ea)	90-Start up Operation	5039329
NAS1149D0332J	Washer	12 Ea (12 ea)	90-Start up Operation	5035396

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3200-1	2	8	0
	D3200-3	2	10	0
	D3201-1	2	6	0
	D3201-3	1	1	0
	D3201-4	1	3	0
	MS21042L3	12	1,637	0
	MS24693-S277	12	127	0
	NAS1149D0332J	12	1,810	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																													
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																																																																																									
Description				Disposition																																																																																											
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 832-6200 Email: sales@dartaero.com www.dartaerospace.com Date: 06/15/18 Container No: S081610 Part: D412-698-015 Job No: 179206 Serial No/Batch: S081610 Revision: G Inspector: Exp Date: Instructions:						Completed By																																																																																									
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Specifications could not be found.

Plex 6/14/18 1:14 PM Dart.lajeunesse.marie

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

7.0 PARTS LIST – PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

REFERENCE ONLY

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